

Date: Wednesday, 2/15/2006 3:46:01 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)					
Job Number	: 25828	Part Number	: D2571					
Estimate Number	: 10530	Drawing Number	: D2571 REV D E CP 06.02.16					
P.O. Number	: N/A	Project Number	: N/A					
This Issue	: 2/15/2006 S.O. No. : N/A	Drawing Revision	: D E					
Prsht Rev.	: NC	Material	: N/A					
First Issue	: N/A	Type	: MACHINED PARTS					
Previous Run	: 25016	Due Date	: 3/15/2006 Qty: 10 Um: Each					
Written By	: See comment below							
Checked & Approved By	: DJ 06.02.16							
Comment	: Est: 10200.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ							

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101007	7075-T7351 8.25X7.75X2.5	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2571 Ensure that grain is along 7.75" length Batch No: 8 34893 (15) J.G. 06/03/13 15	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No: 35838 Double check by: SD	
		1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.	BG For J.G. 15
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572	En / BG For J.G. 15
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	En / BG For J.G. 15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2571 PAR #: N/A Fault Category: Prod / Machined part NCR: Yes No DQA: DS Date: 06/03/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>25828</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/03/14	=	one (1) 540DLC (D2571) SCRAP Dim "w" ranges from 0.166" to 0.116" instead of 0.125".  incorrect amount of shims used	<u>RA</u> <u>06/03/14</u>	-SCRAP Idshny and Replaces -Remove the shim and use <del>used</del> correct amount.	<u>ER</u> 06/03/15	<u>DS</u> 06/03/15	<u>DS</u> 06/03/15	<u>JL</u> 06/03/15

NOTE: Date & initial all entries

Date: Wednesday, 2/15/2006 3:46:01 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 25828

Part Number: D2571

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

BL 06.03.22

15

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

DC 06/03/22 (15)

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DC 06/03/22 (15)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

PC 06/03/22 (15)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 478

PC 06/03/22 (15)

10.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

WADP 06/03/23  
W 06/03/23

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	25828
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.438	0.438	0.438	0.438		
B	1.745	1.755		1.746	1.746	1.749	1.748		
C	3.495	3.505		3.495	3.496	3.496	3.496		
D	1.745	1.755		1.746	1.746	1.750	1.750		
E	7.990	8.010		8.002	8.001	8.002	8.001		
F	0.490	0.510		0.506	0.501	0.509	0.508		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510		0.500	0.500	0.498	0.498		
J	1.174	1.184		1.177	1.177	1.179	1.179		
K	0.558	0.578		0.566	0.566	0.571	0.570		
L	1.174	1.184		1.177	1.177	1.178	1.178		
M	1.490	1.500		1.493	1.494	1.498	1.499		
N	2.495	2.505		2.495	2.496	2.497	2.497		
O	3.869	3.879		3.871	3.872	3.874	3.874		
P	0.115	0.135		0.126	0.125	0.126	0.125		
Q	0.115	0.135		0.130	0.130	0.130	0.130		
R	0.240	0.260		0.249	0.248	0.244	0.244		
S	0.115	0.135		0.126	0.127	0.130	0.130		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.241	0.242	0.236	0.235		
W	0.115	0.135		0.122	0.123	0.125	0.126		
X	0.308	0.313		0.316	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.362	0.361	0.361	0.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.630	0.629	0.625	0.624		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.244	0.255	0.254		
AE	1.375	1.395		1.387	1.386	1.387	1.386		
AF	0.115	0.135		0.130	0.130	0.130	0.13		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.241	0.241	0.245	0.245		
AI	2.000	2.020		2.007	2.000	2.000	2.000		
AJ	0.023	0.043		0.030	0.032	0.030	0.030		
Accept/Reject									

Measured by:	EN / S.G.
Date:	06/03/16

Audited by:	BG
Date:	06.03.22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD

Work Order:

25828

Description: Saddle, Fwd Outboard

Part Number:

D2571

Inspection Dwg: D2571 Rev. E

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.438	0.438	0.438	0.438		
B	1.745	1.755		1.747	1.747	1.745	1.745		
C	3.495	3.505		3.499	3.500	3.495	3.496		
D	1.745	1.755		1.747	1.747	1.745	1.745		
E	7.990	8.010		8.001	8.003	8.006	8.006		
F	0.490	0.510		0.501	0.500	0.499	0.492		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510		0.500	0.501	0.498	0.500		
J	1.174	1.184		1.177	1.177	1.177	1.177		
K	0.558	0.578		0.568	0.568	0.564	0.565		
L	1.174	1.184		1.177	1.177	1.177	1.177		
M	1.490	1.500		1.499	1.499	1.494	1.493		
N	2.495	2.505		2.495	2.496	2.495	2.497		
O	3.869	3.879		3.872	3.872	3.872	3.871		
P	0.115	0.135		0.120	0.120	0.127	0.127		
Q	0.115	0.135		0.130	0.130	0.130	0.130		
R	0.240	0.260		0.250	0.249	0.240	0.240		
S	0.115	0.135		0.130	0.130	0.126	0.126		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.240	0.240	0.235	0.236		
W	0.115	0.135		0.130	0.131	0.125	0.125		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.362	0.362	0.360	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.625	0.625	0.629	0.629		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.245	0.240	0.240		
AE	1.375	1.395		1.387	1.387	1.390	1.390		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.250	0.250	0.240	0.240		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

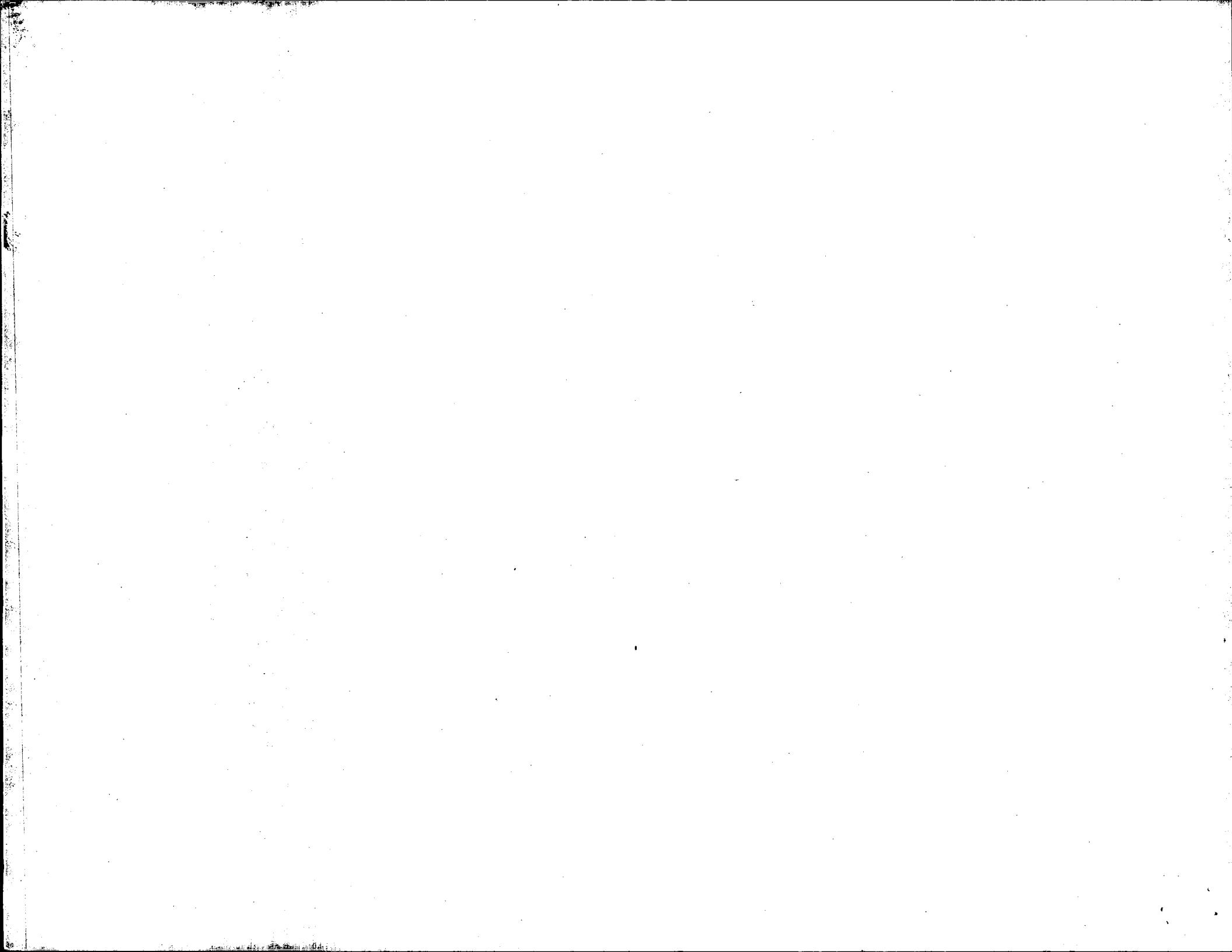
Measured by: J.G /

Date:

Audited by: BG

Date: 06.03.22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	



DART AEROSPACE LTD	Work Order:	25828
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.438	0.438	0.438	0.438		
B	1.745	1.755		1.746	1.746	1.746	1.745		
C	3.495	3.505		3.496	3.496	3.498	3.495		
D	1.745	1.755		1.746	1.746	1.746	1.745		
E	7.990	8.010		8.005	8.005	8.005	8.006		
F	0.490	0.510		0.492	0.493	0.494	0.495		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510		0.500	0.500	0.500	0.501		
J	1.174	1.184		1.177	1.177	1.177	1.178		
K	0.558	0.578		0.565	0.564	0.568	0.566		
L	1.174	1.184		1.177	1.177	1.177	1.178		
M	1.490	1.500		1.493	1.493	1.494	1.496		
N	2.495	2.505		2.496	2.496	2.497	2.498		
O	3.869	3.879		3.873	3.871	3.871	3.872		
P	0.115	0.135		0.129	0.129	0.127	0.127		
Q	0.115	0.135		0.130	0.130	0.130	0.130		
R	0.240	0.260		0.240	0.241	0.240	0.247		
S	0.115	0.135		0.126	0.129	0.126	0.126		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.237	0.240	0.240	0.243		
W	0.115	0.135		0.125	0.124	0.125	0.121		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.362	0.362	0.362	0.362		
AA	0.470	0.530		0.530	0.500	0.500	0.500		
AB	0.615	0.635		0.628	0.632	0.631	0.629		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.242	0.242	0.242	0.243		
AE	1.375	1.395		1.386	1.387	1.387	1.379		
AF	0.115	0.135		0.130	0.130	0.130	0.136		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
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AI	2.000	2.020		2.000	2.001	2.002	2.000		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	EP	Audited by:	RG
Date:	06/03/20	Date:	06-03-22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

D/	AER	PACE LTD	Work Order:	25828
De	ption:	idle, Fwd Outboard	Part Number:	D2571
Ins	cction D:	D2571 Rev. E		Page 1 of 1

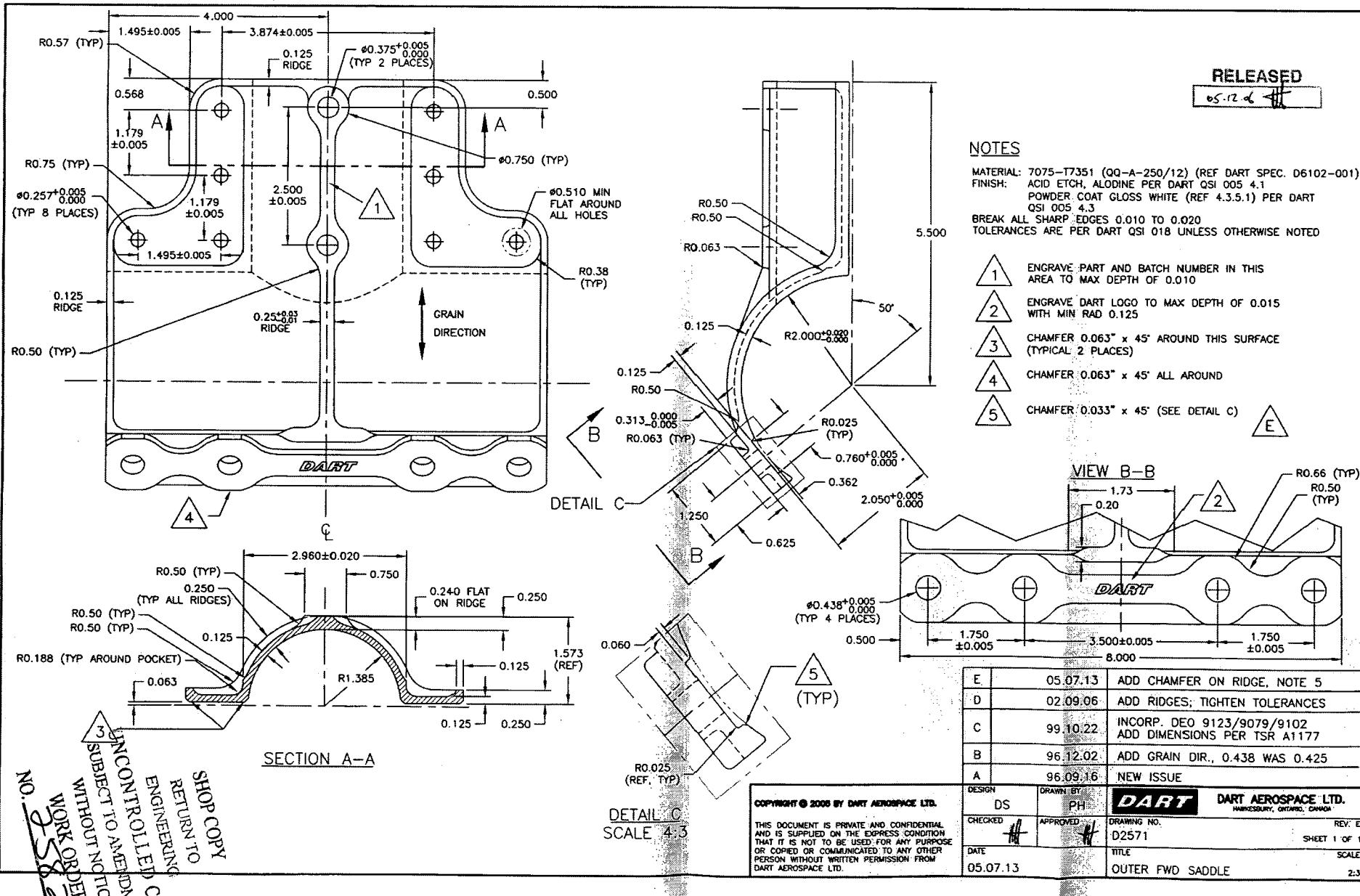
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AA	0.470	0.530		0.500	0.500	0.500			
AB	0.615	0.635		0.631	0.626	0.626			
AC	0.053	0.073		0.063	0.063	0.063			
AD	0.240	0.260		0.252	0.248	0.248			
AE	1.375	1.395		1.380	1.385	1.385			
AF	0.115	0.135		0.130	0.130	0.130			
AG	0.240	0.280		0.260	0.260	0.266			
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AI	2.000	2.020		2.000	2.000	2.000			
AJ	0.023	0.043		0.030	0.030	0.030			

### Accept/Reject

Measured by:	EP	Audited by:	BG
Date:	06/03/20	Date:	06-03-22

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RETURN TO  
ENGINEERING COPY  
ONTROLLED BY  
JECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER NO. 2582